

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input type="checkbox"/>									
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 124342

124342

Page 2

Item ID: D350-578-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bearpaw Installation

Stop ***NS2***

Start Date: 8/27/14 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 9/10/14 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00							
180									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-578-011 Location: <u>F6013</u>								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

DAS

NOV 10 2014

14/11/11

ME
14-11-11

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Offset/Setup									
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FAULT CATEGORY

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Picklist Print

September-11-14 12:02:47 PM

Page 1

Work Order ID: 124342

124342

Parent Item: D350-578-011

D350-578-011

Parent Item Name: Bearpaw Installation

Start Date: 8/27/14

Required Date: 9/10/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-01-02 JLM
 IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC
 IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2182B		Manufactured	No			160	f	320.6200	2.5	10			

D2182B DAS
 Seal(\$Per Foot) 38
 9-89

Location	Loc Qty	Loc Code
ST411	320.62	
101827	1	
108914	2.71	
115189	316.91	

D2274

Manufactured No

D2274 DAS
 Radius Block 38
 9-89

Location	Loc Qty	Loc Code
FG	12	
86855	12	
ST005	747	
109534	6	
110264	2	
112466	2	
115803	107	
117869	357	
121589	273	

10
 12 48

**

DAS
 05
 9-89

NOV 07 2014

48

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FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Page 2

Work Order ID: 124342

124342

Parent Item: D350-578-011

D350-578-011

Parent Item Name: Bearpaw Installation

Start Date: 8/27/14

Required Date: 9/10/14

Start Qty: 4.00

Required Qty: 4.00

D2529 Manufactured No 160 Each 820.0000 12 48

D2529

Washer

DAS
38
9-89

**

DAS
06
9-89

Location	Loc Qty	Loc Code
ST007	820	
109580	7	
115153	113	
<u>119633</u>	600	48
121250	100	

D2438 Manufactured No 160 Each 114.0000 6 24

D2438

Clamp

DAS
38
9-89

**

DAS
06
9-89

Location	Loc Qty	Loc Code
ST542	114	
112483	113	
115202	1	

D2432 Manufactured No 160 Each 1.0000 2 8

D2432

Bearpaw, 19" X 24"

DAS
38
9-89

**

DAS
06
9-89

Location	Loc Qty	Loc Code
ST	1	
111630	1	

AN4-17A Purchased No 160 Each 407.0000 12 48

AN4-17A

Bolt

DAS
38
9-89

**

DAS
06
9-89

Location	Loc Qty	Loc Code
ST343	407	
124858	12	
<u>M128813</u>	195	48
M129909	200	

NOV 07 2014

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Shop Packet Print

Page 2

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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

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Page 3

Work Order ID: 124342

Parent Item: D350-578-011

Parent Item Name: Bearpaw Installation

124342

D350-578-011

Start Date: 8/27/14

Required Date: 9/10/14

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0463J

Purchased

No

160

Each

5,291.000

24 96

NAS1149D0463J

DAS

WASHER

38

9-89

**

DAS

06

9-89

Location

Loc Qty

Loc Code

CA

485

M129682

485

ST277

4806

16941

8

M126221

20

M127813

6

M127904

16

M128591

44

M128995

1500

M129390

3212

96

MS21042L4

Purchased

No

160

Each

4,341.000

12 48

MS21042L4

Locknut

DAS

38

9-89

**

DAS

06

9-89

NOV 07 2014

Location

Loc Qty

Loc Code

ST007

12

121444

12

ST307

4329

126275

5

m126015

12

m126275

27

m127255

63

m127376

11

m127813

831

m128300

69

m128798

811

m129472

1000

m129934

1500

48

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Shop Packet Print

Page 3

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5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -021	Qty -031	Part Number	Description
X						D350-578-011	BEARPAW INSTALLATION
	X					D350-578-013	BEARPAW INSTALLATION
		X				D350-578-015	BEARPAW INSTALLATION
			X			D350-578-017	BEARPAW INSTALLATION
				X		D350-578-021	BEARPAW INSTALLATION
					X	D350-578-031	WEARPLATE KIT
6	6			6		D2182B050	Rubber Cushion
12	12	12	12	12		D2274	Radius Block
12	12	12	12	12		D2529	Washer
6	6			6		D2438	Clamp
2						D2432F	Bearpaw
		2				D2432-3	Bearpaw
				2		D2672F	Bearpaw
					2	D3859-041	Wearplate
		6	6			D4011-1	Clamp
		6	6			D4012-1	Cushion
	2					D4297-1	Bearpaw
			2			D4297-3	Bearpaw
12	12			12	12	AN4-17A	Bolt
	12	12	12			AN4-20A	Bolt
24	12	12	12	24	12	NAS1149D04630	Washer
12	12	12	12	12	12	MS21042L4	Nut (or MS21042-4)

Work Order ID 124342

September-11-14 12:02:48 PM

124342

Page 1

Item ID: D350-578-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw Installation

Start Date: 8/27/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/10/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MJS Date: 14-09-17 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D350-578	G

100 Document Control 0.00

100

DC Memo 0.00

Doc.Control -USB or Paperwork Photocopy bluefile and create labels per PPP D350-578-011 CHG005

MJS 14-11-10

(C)

160 Pick Kit 0.00

160

Packaging Memo 0.00

Packaging

170 QC4- 100% Inspect kits for completeness 0.00

170

QC Memo 0.00

Quality Control